Work Order I Wednesday, June 04,	2014 2.02.20 DM	65-109 20885	*1	120:	385*						Page 1
Item ID: D25 Revision ID: Item Name: Stru	565-109		Accept		*N900	040	1100)*	Setup Sta	1 71	S1* S2*
Start Date: 6/04 Required Date: 6/04 Reference:		*6* *6*	~		Cust Item Customer:				i Light Me		
	ocess Plan: ML5	Date: <u> </u>	Tooling: SPC (Y/N	J):		ate:			Run Sta Sto	, ^IV	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up Run H		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		* 1-			<u>.</u>	-JP.				
D2565	Rev E				- 2 - 1						
100 *100* Brake NC	Punch ends and deburr a NC BRAKE Memo	_	0.00				30 9-89	6x			14/07/070
Brake NC	Punch as p	per Dwg D2565 using DT 8	3313		, ·						,
110	•		0.00		•		٠.		grand .		•
110	Small Fab						DAS 30	(14(0)
Small Fab	Memo Deburr		0.00	245		- :	3-69	-	• .		
120	QC5- Inspect part comp	leteness to step on W/O	0.00	DAS 27 9 ₁ 89]						
120 QC Quality Control	Memo		0.00	WHI	7			۵			

DQA:		_ Date:			WORK ORDER NON	_	2150	D144105 / 11D0 475					TRAC
QA Closed:		Date:			WORK ORDER NON	-((JNFO	RIMANCE / UPDATE	W	ork Order up	odate only	\neg	AEROSPACE
Work Orde	.بر				DISPOSITION			AGAINS		PARTMENT			
work orde	· · ·				Rework	ı		Skid-tube Crosstube	_	1	Water let	_	Fundance in a [7]
Part N	lo				Scrap			Skid-tube Crosstube Machining Small Fak	—	Pro	Water Jet d. Eng. Coor.	_	Engineering Quality
	-				Use-as-is		Therr	noforming Finishing	3	Rec/Sto	e/Packaging	\Box	Other
NCR N	NCR No.			_	Suspected Unapproved			Large Fab Composite	=]	Supplier		
Root				Descr	ription of work order update		Initial	Action		Sign &		Т	
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification		QC Inspector
Design												ヿ	
Doc/Data			l										
Equip/Tooling													
Handling/Pre												Ì	
Material						ŀ							
Operator					· '								
Offset/Setup					`							İ	
Process										l			
Supplier													
Training					1								
Transport [
Unapproved													<u>.</u> .
						FΑŧ	ULT CAT	regory	٠		-		
Landir	g Gear				General		_			_	_		
	Bending		•		Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
	Centre i	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	╝	Set-up
	Cracks				Broken/Damage/Defect	L	Hardwa	re	L	Part Incorred	ci L		Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs	<u> </u>	Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear	L	Part Moved	L		Wrong Stock Pulled
Į	Crushin	3			Countersink		Misalig	ned/off center		Positioned V	Vrong		
Ĺ	Heat Tre	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
į	Inspecti	on Strip in	Tube		Drawing		Misread	t					
` [Marks/0	hatter			Drill Holes		Off-set						
	Turning	Sequence	!		Finish		Out of 0	Calibration					
	Wave/T	wist in Tul	be		Fit/Function		Out of 9	Sequence					

Work Order ID 120385 *120385* Page 2 Wednesday, June 04, 2014 3:03:38 PM Item ID: D2565-109 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Strut *6* Start Date: 6/04/14 Start Otv: 6.00 **Cust Item ID:** Required Date: 6/04/14 Rea'd Otv: 6.00 *6* **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: *NR2* Sequence ID/ Operation Set Up/ Tool ID Tool # Accept Reject Reject Plan Insp. Work Center ID Description **Run Hours** Code **Qty** Oty Number Stamp White Gloss(Ref:4.3.5.2) per QSIQ05.4.3-Steel 130 0.00 *130* Powdercoat 0.00 Memo Powder Coating START TIME: OVEN TEMPERATU FINISH TIME: DAS 140 QC3- Inspect Part Finish *140* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location. 150 LOX 14-7-8 *150*

0.00

Memo

Packaging

Packaging

DQA:		Date:		·		_		`DART				
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		ork Order up	odate only	AEROSPACE
Mork Ordo	<u> </u>				DISPOSITION				/PROCESS			
Work Orde	1.				Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	o				Scrap			Machining	Small Fab	-1	d. Eng. Coor.	Quality
NCR N	0				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root		Ī		Desci	ription of work order update		nitial	Actio	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design		•										
Doc/Data			•									
quip/Tooling										:		
landling/Pre		6							•		_	
Material										} .		
Operator												
Offset/Setup												
rocess												
upplier		1										
raining		ļ										
ransport		İ										
Inapproved												
						FAL	ULT CAT	TEGORY	, .			
Landin	g Gear			_	General		_			_		_
	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	:i	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unc	qualified	Part Lost/Mi	ssing	Weld
Ĺ	Cuffs				Contamination		Instruct	ions Incomplete/Ur	nclear	Part Moved		Wrong Stock Pulled
L	Crushing				Countersink		Misalig	ned/off center	L	Positioned W	/rong	_
	Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other
	Inspection	n Strip in	Tube		Drawing		Misread	i				
	Marks/Ch	atter			Drill Holes		Off-set					
	Turning S	equence			Finish		Out of (Calibration				
	Wave/Tw	ist in Tub	oe		Fit/Function		Out of 9	Sequence				

Work Order ID 120385 *120385* Page 3 Wednesday, June 04, 2014 3:03:38 PM D2565-109 Accept Item ID: *N900040100* Setup Start Revision ID: Stop Item Name: Strut *6* **Start Date:** Start Oty: 6.00 6/04/14 **Cust Item ID:** Required Date: 6/04/14 Rea'd Otv: 6.00 *6* **Customer:** Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Qty Number Stamp Run Hours Code Qty 160 QC21- Final Inspection - Work Order Release 0.00 *160* OC^T 0.00 Memo

Quality Control

DQA:			- Date:			WORK ORDER NON	WORK ORDER NON-CONFORMANCE / UPDATE												
QA Closed:			Date:			WORK ORDER NON	-((JNFO	RIVIANCE / UF		ork Order up	odate only	AEROSPACE	:					
Work Orde	۵r۰			•	-	DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	· · · · · · · · · · · · · · · · · · ·						
Part N	۱o. ِ					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other						
Root					Desc	ription of work order update		Initial	Acti	on	Sign &			_					
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector						
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved																			
							FA	ULT CAT	TEGORY					_					
Landi	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unicions Incomplete/U gned/off center eled	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other								
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence										

Wednesday, June 04, 2014 3:03:37 PM

Work Order ID: 120385

120385

Parent Item:

D2565-109

D2565-109

Parent Item Name: Strut

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	791.7261	1.0258	7		DAS	
M304TR	750W	049							**			30 9-89	14/0

304 RD Tube .750 x .049W

Location	Loc Oty	Loc Code	
MAT017	791.7261		
122312	4.04		
124768	49.27		
M126183	25.4399		_
M128084	44.9762		_
M129188	268		- 4
M129363	400		_

DQA:		Date:											
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPD			–	AEROSPACE	
QA Closed:		Date:							W	ork Order up	date only		
Work Orde	r:				DISPOSITION				/PROCESS				
					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	0.				Scrap			├ ──-	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is			noforming	Finishing	4	re/Packaging	Other	
NCR N	o				Suspected Unapproved			Large Fab C	Composite]	Supplier		
Root	\top			Desci	ription of work order update		I Initial	Action	<u></u>	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descript	ion	Date	Verification	QC Inspector	
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Doc/Data		ļ											
quip/Tooling			1										
landling/Pre													
Material				ŀ									
Operator													
Offset/Setup							•						
rocess	_												
upplier													
raining													
ransport]									
Inapproved		<u> </u>				<u> </u>							
				· · · · · · · · · · · · · · · · · · ·		FA	ULT CA	regory					
Landin F	g Gear				General	_	1 /-		_	1		7- /	
-	Bending			<u> </u>	Bend BOAA/Bassas	<u> </u>	1	Program	<u> </u>	Outside Dim	}	Pressure/Forced	
}	Centre No	ot Conce	ntric		BOM/Route	H	Grain			Over/Under	<u> </u>	Set-up	
ŀ	Cracks Crimp/Kir	ak/Dianla	//// 24/2	\vdash	Broken/Damage/Defect Burrs	_	Hardwa	ire ion Incomplete/Unqui	alified	Part Incorred Part Lost/Mi	<u> </u>	Temperature/Cure Weld	
}	Cuffs	ik/kibbie	y wave	\vdash	Contamination		1	ions Incomplete/Uncl		Part Moved	-	Wrong Stock Pulled	
]-	Crushing			-	Countersink	<u> </u>	4	ned/off center		Positioned W	/rong	TANTOLIS STOCK Latter	
}	Heat Trea	nt			Cut Too Short	\vdash	Mislabe		\vdash	Power Loss/		Other	
ł	Inspection		Tube		Drawing		Misrea		<u> </u>	Trower coss/surge Other			
	Marks/Ch	•			Drill Holes		Off-set						
ļ	Turning S				Finish	_	4	Calibration					
ļ	Wave/Tw				Fit/Function		4	Sequence					
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DAKI AEN	A COST ACT				·	AEROSP
Description:	hub				Work O	rder: 140365
					Part Nun	nber: D2565-109
nspection Drawin	g: D206	5	Rev:	É	Fait Nui	IDET. 12365 101
		1814	CDEC	TION!	CHEET	
	1	IIV:	SPEC	IUN	SHEET	n Comments
Drawing Dimension	on Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	81-5
12.31	16-030	12.325				
11.51	1/2.000	<u> 12 · S 3</u>			1-1	- 815 - 3
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